

## Finger joint cutter

### A16-280

Latest grinding technology for finger joint cutters.  
Best grinding time cycles, excellent surface and  
accurate clearance angle on the tooth flank.

#### 1. Cycletime for production

##### Tool specifications

Diameter	160 mm				
No of cutting edges	4 33				
Length of cutting edges	mm				
Helix	0 deg				
Material	HSS				
Operations	Probing	Roughing	Flute	Outer diameter	Finishing
Feed [mm/Min]	2000	60	250	300	300
Power [kW]	2	12	2	1	1
Cutting feed [m/s]	-	32	32	32	32
Grinding wheels		5	3	2	6+6
Grinding time [s]	19	1380	270	225	840
Total cycle time	approx. 45 Min				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerable.

#### 2. Used grinding wheels

- 2 Ø75B126 11V9
- 3 Ø125B126 12V9
- 5 Ø175B126 shaped wheel
- 6 Ø175B126 12V2

#### 3. Machine and Software requirements

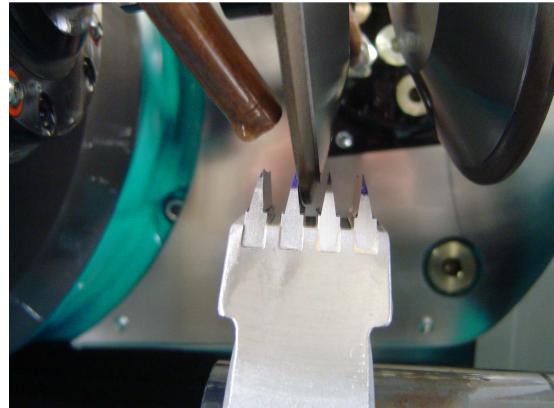
Machine: 5 axes CNC: GEMINI DMR  
Control : Fanuc 160i  
Coolant: Emulsion, pressure 6 – 7 bar  
Software: Quinto 4.2, dxQ

HM 7.5.07

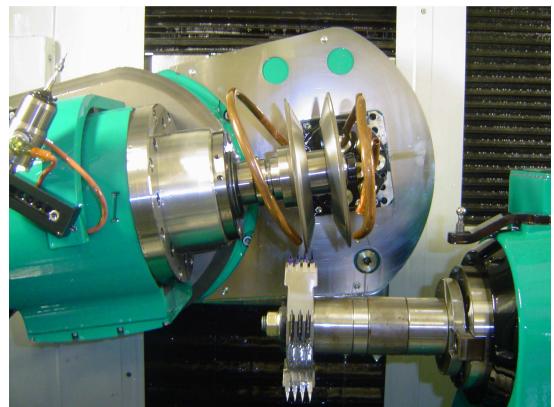
[www.schneeburger.ch](http://www.schneeburger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

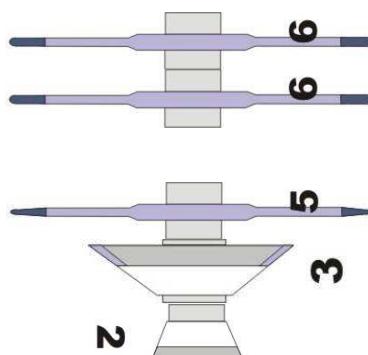
Subsidiaries in: France, Deutschland, Italia, United States, United Kingdom, China



Finger joint cutters are ground on diameter, face and tooth flank.



Finishing wheels with axial or concave shape



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